

Date: Monday, 6/5/2006 7:48:17 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BRACKET
Job Number	: 27384		
Estimate Number	: 10283		
P.O. Number	: N/A	Part Number	: D31991
This Issue	: 6/5/2006 S.O. No. : N/A	Drawing Number	: D3199 REV A1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : SMALL / MED FAB	Drawing Revision	: A1
Previous Run	: 25557E	Material	: N/A
Written By	: <i>SEE COMMENT BELOW</i>	Due Date	: 6/30/2006
Checked & Approved By	: <i>06.05.05</i>	Qty:	<i>60</i> Um: Each
Comment	: Est Rev:C Removed Scribing 05-11-05 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0

PG

PURCHASING



Comment: PURCHASING

Issue P/O: *1407*

Email or Ship DXF file to vendor

Laser Cut D3199-1 bracket per Dwg D3199

Material release note is required

2.0

D31991F

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 40.0000 Each(s)
 Bracket

3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

4.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1-Deburr if necessary

2-Form as per Dwg D3199

m.f. 06/07/13
JB 06/07/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/08/01

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 6/5/2006 7:48:17 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 27384

Part Number: D31991

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



06-07-20 (65)

Comment: INSPECT WORK TO CURRENT STEP

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

0.21 06-07-24

(65)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PU 6/7/25 (64)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST 138*

LB 06-25-07 (64)

(65)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/08/01 (64)

Job Completion



C20713112004

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

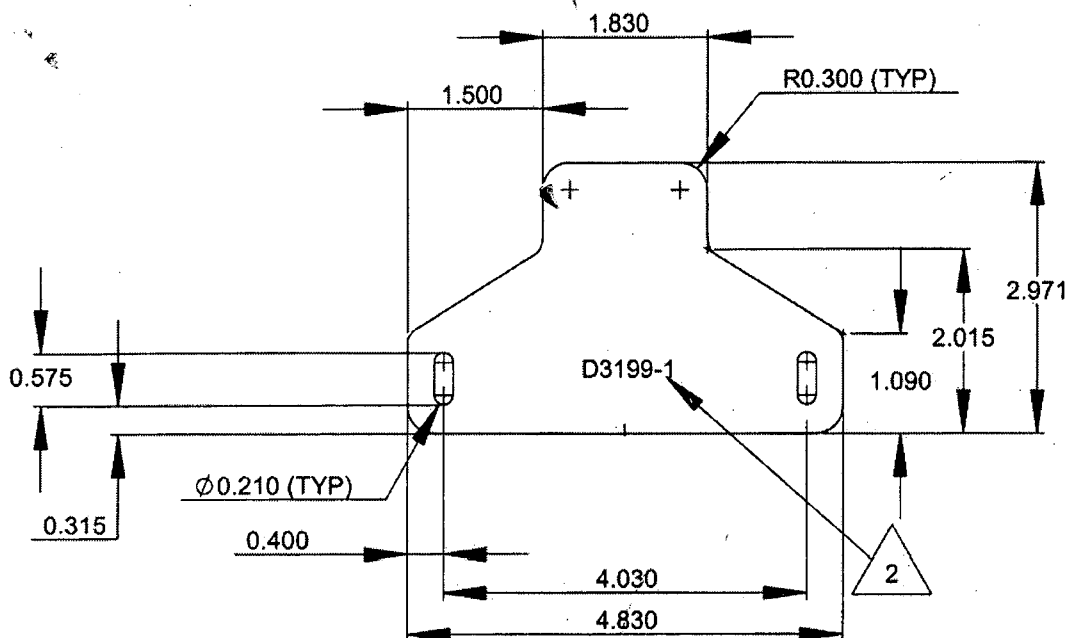
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

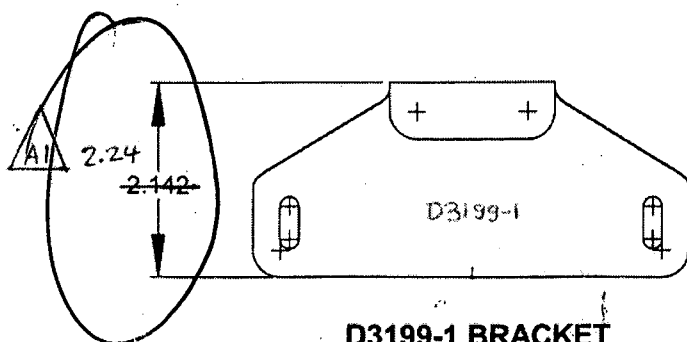


DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	#	APPROVED	#	DRAWING NO. D3199 REV. A SHEET 1 OF 1
DATE	03.08.05	TITLE	BRACKET	SCALE 1:2
A	03.08.05	NEW ISSUE		
AI	04.03.01	#	2.24 WAS 2.142	

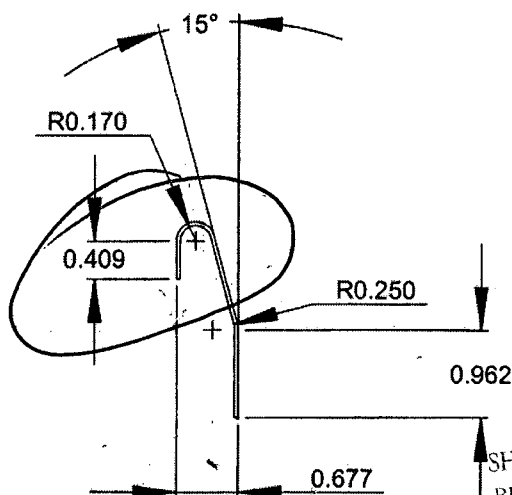
RELEASED
03.09.02



D3199-1 FLAT PATTERN



D3199-1 BRACKET



NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET 0.040" THICK PER MIL-S-5059 (REF DART SPEC. M304S)
- 2) SCRIBE DART P/N D3199-1 AS SHOWN.
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES.

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27384

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#7 - 7504 Vantage Place
Delta, B.C. V4G 1A5
PH: (604) 946-4152
FAX: (604) 946-4153
EMAIL: info@industrialaser.com

Packing List

Bill Dart Aerospace
To: 1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Ship Dart Aerospace
To: 1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Shipment No: 12353
Shipment Date: 06/29/06
Ship Via: Fedex
Order Number: 10011
Order Date: 06/06/06

Customer Code: DART
Phone: (613) 632-3336
PO Number: 1407
Terms: Net 30 Days

Item	Quantity					Unit	Description	Revision	Job Number
	Open	Shipped	Back Ord	Canceled					
1	60	60	0	0	EA	D31991F Bracket - dwg.D3199-1 Rev.A1		10011-01	

65
6/4/30

Packing Clerk's Initials
Industrial Laser Cutting

Received In Good Order By
Dart Aerospace



NORTH AMERICAN STAINLESS

METALLURGICAL TEST REPORT

**6870 Highway 42 East
Ghent, KY 41045-9615
(502) 347-6000**

Certificate: 278331 01

Mail To:
WILKINSON STEEL AND METALS
ATtn: MILL CERTIFICATE SCANNER
226 SOUTHEAST MARINE DRIVE
VANCOUVER, BC V5X2V3
CANADA

Ship To:
WILKINSON STEEL AND METALS
888 SOUTHEAST MARINE DRIVE
VANCOUVER, BC V5X2V3
CANADA

Date: 8/13/2005 Page: 1

Steel: 304

FILE NO: 20

Your Order: P50630PC001V

NAS Order: AE 0322595 03

Corrosion: ASTM A262/02aE; 180Hend-OK

PRODUCT DESCRIPTION:

STAINLESS STEEL SHEET, COLD ROLLED, ANNEALED AND PICKLED.
ASTM A240/04a, 480/04a, 666/03, ASTM A240/04, SA480/04, SA666/04
Q88766D-A X MG PRN, AMS5513H X NKKKFIN, MIL5059D, AND3, X CRWN MEAS

REMARKS:

Material free from mercury contamination. No weld repairs.
EN 10204 3.1.B QQS763F Cond A

Product ID #	Coil #	Thickness	Width	Weight	-----Length-----	Mark	Pieces
B36382	* 0574K7 BB	.0360	48.0000	2,820 SHEET	96.000	5	62

CHEMICAL ANALYSIS

CHEMICAL ANALYSIS

Heat	C	CR	CU	MN	MO	N	NI	P	S	SI
74K7	.052	18.110	.360	1.642	.304	.064	8.131	.027	.003	.313

MECHANICAL PROPERTIES

MECHANICAL PROPERTIES

Product ID #	Coil #	1 d o i c r	UTS KSI	.2% YS KSI	ELONG %-2"	Hard RB	Tail Hard
B36382	0574K7	P T	96.33	50.72	45.54	83.50	88.00

QC ENGINEER

ERIC HESS

8/13/2005